

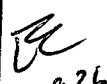

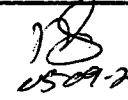
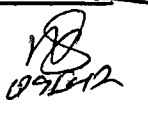
DART AEROSPACE LTD		Work Order:	24209
Description: Wearplate		Part Number:	D3319-1
Dwg: D3319 Rev. <u>B per PH 05-09-02</u> A page 1		Qty:	4
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05-09-02	4
2	PG	Issue P/O: <u>2008582</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3319 Possible Supplier: Industrial Laser Material release note is required	U	05-09-02	4
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CL	05/09/20	4
4	QC6	Inspect dimensions as per inspection template D3319-1T1	U	05-09-20	4
5	GA	Deburr if necessary	N/A	U	
6	GB	Form using DT8326 & DT8261 as per Dwg D3319 Dwg Rev: <u>B</u>	SB	05/09/20	4
7	GB	Form flat on press using DT8776 block Dwg Rev: <u>B</u>	SB	05/09/22	4
8	QC6	Inspect dimensions as per Dwg D3319	U	05-09-22	4
9	WS	Trace weld location using D3319-1T3 & Dwg D3319 Weld hard surface using D3319-1T2 as per QSI 004 and Dwg D3319 Dwg Rev: <u>B</u> Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod <u>M17914</u>	CPL	05-09-26	2
10	QC9	Inspect weld	CPL	05-09-26	2
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	ML	05-09-27	2
12	QC3	Inspect Powder Coat	CL	05/09/27	2
13	ST	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA04-18 PDA05-18 and Stock	SB CL	05/09/27 05/09/27	2 2
14	AC	Cost / part: <u>90.56</u>	SAC	05-09-27	2
15	DC	Close W/O Inspect Level 21	U	05/09/28	2

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM	

PRELIMINARY ISSUE

Procedure change

			by	date	app. QC	app. Dsg Mng
dep 8b	 05.09.26	add step 8b to base layout weld location with new jig D3319-IT3		05.09.26	 05.09.27	 09.10.12

8b U Remove 1 for weld jig 05.09.26 U

SHOP COPY

RETURN TO

ENGINEERING

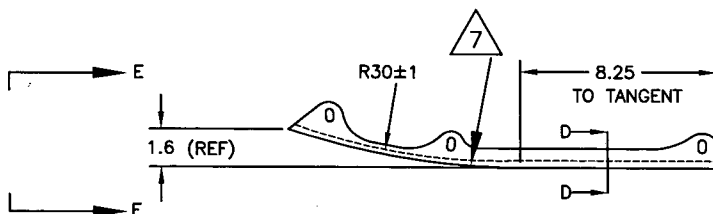
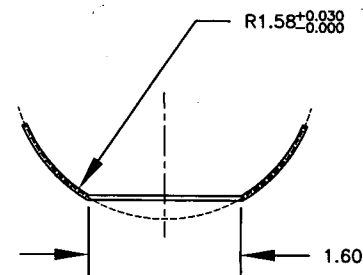
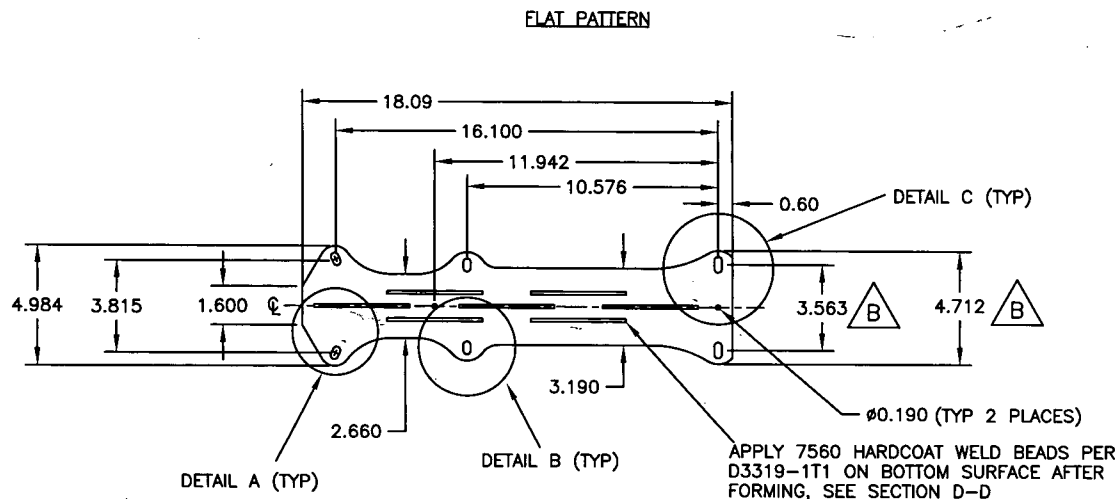
UNCONTROLLED

SUBJECT 1

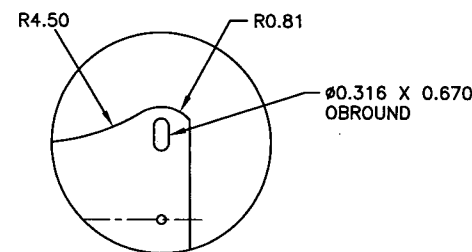
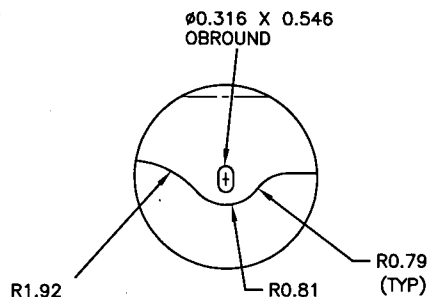
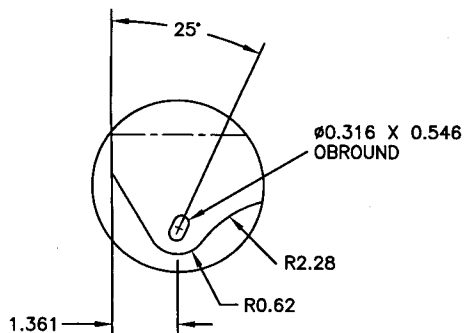
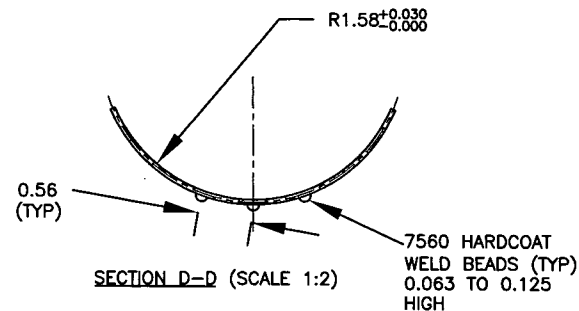
WITH YOU

WORK ORDER

NO. 24789



BENDING DETAIL



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 1 OF 5
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE 1:8

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 02, 2005
01:45 pm

Work Order No : 0024209
Project Name : D3319-1
Project For : WK537
Work Order Type : Main
Main WO Number :
House Part Number : D3319-1
Description : Wearplate
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 09-02-05
Est Finish Date : 09-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8998 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5005/21329

STEEL

Form (09) 375 8759

CUSTOMER		Wilkison		P41007DI002		SPECIFICATION		ASTMA1008 CS Type A		CERTIFICATE No		TC107797	
CUSTOMER O/N		90-21N-288				PRODUCT		CRA WIDE COIL		PAGE		1 of 1	
MILL O/N		453666				DIMENSIONS		0.044" x 48" x Coil		DATE		31 March 2005	

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)											
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH				
		x100			x1000												x10000		x100		180°				HRB		()	
R9-455948-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					Good				49		1729				
R9-455949-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					Good				49		1296				
R9-455951-00	638405	5	1	20	13	19	12	19	17	1	5	1	1					Good				49		2064				
R9-456216-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1					Good				54		1926				
R9-456217-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1					Good				54		1978				
R9-456218-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1					Good				52		1926				
R9-456219-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1					Good				52		1978				

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.)			PLASTIC STRAIN RATIO (r)		IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm		CARBON EQUIVALENT VALUE (CE)	
	(A)=200mm (B)=50mm	(C)=80mm (D)=5.65 * So	(E)=Z (F)=8"	(A)=r0 (B)=r90	(C)=r45 (D)=(r0+r90+2r45) / 4				(A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15	(C)=C+Mn/6+Si/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

18 ga CRMS

11MD014-2 T M INDUSTRIAL (P41007DI002.636939)

Peter Hum

From: David Shepherd [davids@dartaero.com]
Sent: Tuesday, September 27, 2005 10:50 AM
To: Peter Hum
Subject: Re: D3319-1/-3 changes

Peter,

It is acceptable to ship these parts. I will sign off the updated drawings when I am in Hawkesbury later this week.
Please ensure W/O refers to Rev. B of the drawings.

David

----- Original Message -----

From: "Peter Hum" <phum@dartaero.com>
To: "David Shepherd (E-mail)" <davids@dartaero.com>
Sent: Tuesday, September 27, 2005 8:39 AM
Subject: D3319-1/-3 changes

> David,
>
> The D3319-1/-3 wearplates for use on the D350-727-015 kit have been
modified
> to Rev. B. Rev. B has not been released. A fit and function has been
> performed and photographed to show that the D3319-1/-3 Rev. B wearplates
fit
> an OEM 350 skidtube. Is it suitable to ship the D3319-1/-3 wearplates at
> Rev. B?
>
>
> Peter
>
>